Ionday, January 20, 2014 3:37:14 PM		*111738*								Page 1
em ID: D3440-5		Accept	*N900	040	100)*	Setup S		*N:	S1*
em Name: Contoured Detent Clip Base (Supe	ersedes B67-43001-217)						1	Stop	*N:	S2*
tart Date: 1/20/2014 Start Qty: 12.	00 *12*		Cust Item II	D:						
equired Date: 1/31/2014 Req'd Qty: 12.			Customer:							
eference:								•		
pprovals: Process Plan: W.L.	Date: 14-1-20.	Tooling:	Da	te:	_		Run S	Start	*N	R1*
QC:	Date:	SPC (Y/N):	Da				:	Stop	*N	R2*
equence ID/ Operation Vork Center ID Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rejec		Reject Number	Insp. Stamp
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D3440 Rev A										
00 BAND SAW		0.00				12	<u></u>	 §		
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aspa Bandsaw Cut blan	nk: 1.250" x 1.250" x 2.000" lon	ıg								
10	•	0.00								4.1
	CAL MACHINING #1					12	Ô	Y		St 14-01-
HAAS 1 Memo		0.00				-				

120

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

120

Quality Control

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DQA: Date:						DART									
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	-					Rework			Skid-tube	Crosstube	-		Water Jet	Engineering	
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NCR N	lo.					Suspected Unapproved]	mem	Large Fab	Composite		Necy 3to	Supplier		
Root					Desci	ription of work order update	1	nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector	
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i a a di						Conoral	FA	ULI CA	TEGORY						
Landi	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misread Off-set	ion Incomplete/U cions Incomplete/ gned/off center eled d	/Unclear		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
	Waye/Twist in Tube				1 _{Fit/Function}		Out of	Saguence							

Work Order ID 111738

111738

Page 2

Monday, January 20, 2014 3:37:14 PM Item ID: D3440-5 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Contoured Detent Clip Base (Supersedes B67-43001-217) **Start Date:** *19* 1/20/2014 **Start Oty: 12.00 Cust Item ID:** Required Date: 1/31/2014 **Reg'd Otv:** 12.00 *10* **Customer:** Reference: Start Run Process Plan: Date: Tooling: **Approvals:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Reject Operation Set Up/ Tool ID Tool# Plan Reject Accept Insp. **Work Center ID Description** Qty Qty **Run Hours** Code Number Stamp 130 QC8- Inspect parts - second check 0.00 *130* OC 0.00 Memo Quality Control Identify as per dwg & Stock Location: Mezz 2 140 DAS 12x 28 14-01-27 *140* **Packaging** 0.00 Memo **Packaging** 150 QC21- Final Inspection - Work Order Release 0.00 MLJ 1401-27 *150* OC 0.00 Memo Quality Control

DQA:			Date:			,							TRAGE	
OA Clasadi			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	١٨/،	ork Order up	odate only	AEROSPACE	
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-	\neg	Crushing			<u> </u>	Countersink	-	-	gned/off center	-	Positioned V	_	Other	
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H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Page 1

Monday, January 20, 2014 3:37:13 PM

Work Order ID:

111738

Parent Item:

D3440-5

Parent Item Name:

Contoured Detent Clip Base (Supersedes B67-43001-217)

Start Date: 1/20/2014

Required Date: 1/31/2014

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP A05.06.30New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.250 6061-T6 Bar 1.25 x 1.25		Purchased	No				f	12.6250		3			
				Location		Loc Oty	<u>La</u>	oc Code					
•				MAT003		12.625							
				1244	43	0.625			_ 2	· 1	FB 1	4/01/	24
				m12e	6647	12							

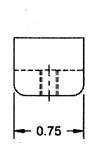
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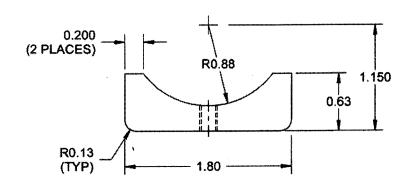
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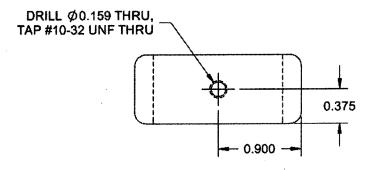


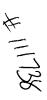
DESIGN D	RAWN BY	DART AEROSPACE L HAWKESBURY, ONTARIO, CAN	
CHECKED A	PP (VED	DRAWING NO. D3440	REV. A SHEET 3 OF 7
DATE 05.06	.02	BLADE FOLD KIT PARTS	SCALE 1:1











D3440-5 CONTOURED DETENT CLIP BASE SUPERSEDES PREMIER P/N B67-43001-217

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DQA:	Date:					WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER NON-	-CC	JINFUI	KIVIANCE / U		Wo	ork Order up	date only		AEROSPACE
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DART AEROSPACE LTD	Work Order:	111734
	•	
Description: Contoured Detent Clip Base	Part Number:	D3440-5
Inspection Dwg: D3440 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	X Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.750			5108	Vem
0.200	+/-0.010	. 200	/			
0.63	+/-0.030	.627				
1.80	+/-0.030	1.800			V	
R0.13	+/-0.030	.125	/		Rad 6	augl
						V

	17 11		/ /	I VA CO		
Measured by:	SI	Audited by:	DRI	80	Prototype Approval:	N/A
Date:	14-01-25	Date:	14-01-2	6	Date:	N/A

Rev	Date	Change	Revised by	Approv	_
Α	05.09.19	New Issue	KJ/JLM SX	\J\I\	/
	•				

DQA:			Date:											T A A RT	
						WORK ORDER NON-CONFORMANCE / UPDATE									
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Work Order:						DISPOSITION				AGAINST [DEP	PARTMENT/PROCESS			
						Rework	1 		Skid-tube	Crosstube			Water Jet	Engineering	
Part No.						Scrap			Machining Small Fab		٦	Prod. Eng. Coor.		Quality	
						Use-as-is		Thermoforming Finishing				Rec/Stor	e/Packaging	Other	
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<u> </u>		Bending				Bend	-	Folio/Program			-	Outside Dimensions		Pressure/Forced	
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-		Crushing				Countersink	\vdash	Misaligned/off center			\dashv	Positioned V	L. Vrong		
	_	Heat Treat				Cut Too Short	\vdash	Mislab	•	Lyon center		Power Loss/Surge		Other	
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